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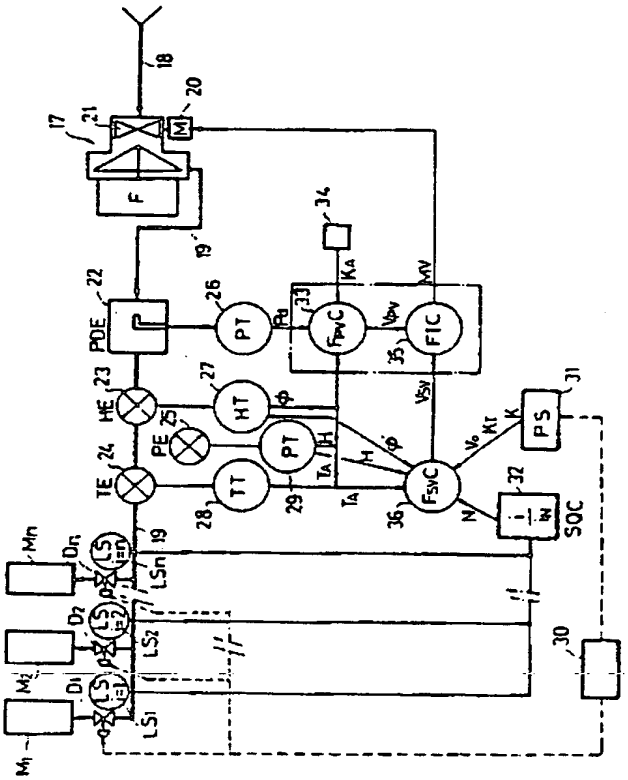
TITLE : CONTROLLING METHOD FOR AIR QUANTITY COOLING MOLD



ABSTRACT : PURPOSE: To automatically obtain the optimum cooling air quantity and to mold a good-quality glass product by sensing the air quantity of cooling air fed to a mold and comparing it with the preset value calculated by a specified equation and controlling the above-mentioned cooling air quantity in basing on the deviation amount.

CONSTITUTION: A glass product is formed by casting a high-temp. gob into molds M_1, M_2...M_n and passing the cooling air sent from a blower 17 through an air duct 19 and feeding it via dampers D_1, D_2...D_n to cool the molds. Each detected value of a pressure difference detector 22, a humidity detector 23, a temp. detector 24 and an atmospheric pressure detector 25, etc., provided to the above-mentioned air duct 19 is inputted to an arithmetic unit 33 for measured value of air quantity via respective converters 26~29 and the above-mentioned cooling air quantity is sensed. On the other hand, in an arithmetic unit 36 for preset value of air quantity, the preset value of air quantity is calculated by a formula VSV = N(VO + KTTA) (wherein VSV is preset value of air quantity, VO is reference air quantity defined by kind of product, KT is air quantity/temp. factor defined by kind of product, TA is temp. of cooling air and N is number of set of worked mold). The above-mentioned air quantity is compared with the preset valve of air quantity in a comparator 35, and a motor 20 for the suction vane 21 of the blower 17 is controlled in basing on the deviation amount thereof.

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